Work Order ID 75229 *75229* Page 1 October-19-11 11:10:41 AM Item ID: D3436-5 Accept *N900040100* Setup Start **Revision ID:** Item Name: Bushing **Start Date:** 19/10/2011 Start Qty: 20.00 *20* **Cust Item ID: Required Date: 07/11/2011** Req'd Qty: 20.00 **Customer:** Reference: Run Start Process Plan: ML. J Date: 11/10/19 Approvals: Tooling: Date: Stop Date:_____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. **Work Center ID** Description **Run Hours** Code Qty **Qty** Number Stamp Draw Nbr **Revision Nbr** Rev A D3436 100 0.00 Hardinge CNC LATHE SMALL *100* 20 Ø 1 A 11/10/20 Hardinge 0.00 Memo Hardinge CNC Lathe Small Turn as per Folio FA526 and Dwg D3436, Deburr 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* 11/10/20 0.00 Memo Quality Control 120 QC8- Inspect parts - second check 0.00 JL 11-10-21 *120* QC 0.00 Memo

Quality Control

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W/O:			W	ORK ORDER CHAN	GES				
DATE	STEP	PRO	OCEDURE CH	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC	Corrective Action		ection B Sign		cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Dat		ion C	Chief Eng	QC Inspector
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Work Order ID 75229 *75229* Page 2 October-19-11 11:10:41 AM Item ID: D3436-5 Accept *N900040100* Setup Start **Revision ID:** Item Name: Bushing **Start Date:** 19/10/2011 **Start Oty: 20.00 Cust Item ID: Required Date: 07/11/2011** Req'd Qty: 20.00 **Customer:** Reference: Run Start Approvals: Process Plan: Date: Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Reject Tool # Plan Accept Reject Insp. **Work Center ID** Description Code **Qty** Number Stamp **Run Hours** Oty Identify as per dwg & Stock Location: 130 0.00 *130* Packaging 0.00 Memo Packaging *****STOCK IN LARGE FAB***** 140 QC21- Final Inspection - Work Order Release 0.00 *140* 0.00 Memo Quality Control

11-10-2

W/O:			W	ORK ORDER CI	HANGES				· · · · · · · · · · · · · · · · · · ·	
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Page 1

Work Order ID: 75229

75229

Parent Item:

D3436-5

D3436-5

Parent Item Name: Bushing

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP A05.05.11New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.373W.049 +		Purchased	No			100	f	18.8670	0.1083	2.28			
M4130N7	0.373	V 049							**				,

4130 RD tube .373 x .049W

Loc Qty Loc Code Location MAT032 18.867 **✓**111329 18.867

Dart	Aer	os	pace	Ltd
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Dart Ae	rospace	e Ltd	•							p ·	
W/O:			WC	RK ORDER CHANG	GES			-			
DATE	STEP	PRO	CEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	Part No: PAR #:		Fault Cate	norv.	NC	R· Yes	No DQ	Δ.	Date:		
					QA: N/C Closed:						
NCR:		V	VORK ORD	ER NON-CONFORM	ANCE	(NCF)				
		Description of NC		Corrective Action Sec	tion B		Verific	ration	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector	
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DART AEROSPACE LTD	Work Order:	75229
Description: Bushing	Part Number:	D3436-5
Inspection Dwg: D3436 Rev: A		Page 1 of 1

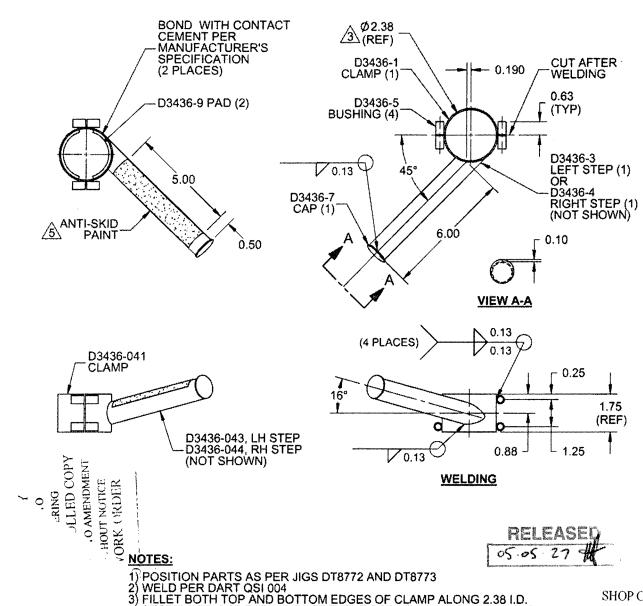
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection		nments
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asured by:	H.A	Audited by:	<i>K</i>		Prototype	Approval:	N/A
Date:	11/10/20	Date:	11-10-2			Date:	N/A

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		solution:							
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DATE	STEP	Description of NC		n B	Verifica	tion	Approval	Approval	
DAIL	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	1 C	Chief Eng	QC Inspector



DESIGI N	1B	DRAWN BY MB	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
CHECK	ED#	APPROVED #	DRAWING NO.	REV. A SHEET 1 OF 4
DATE	05.0)4.28	MAINTENANCE STEP	SCALE 1:4
Α	0	5.04.28	NEW ISSUE	



3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE

4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3

5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4

6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

7) ALL DIMENSIONS ARE IN INCHES

SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

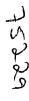
WORK ORDER 15229 NO.

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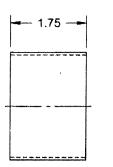
11/10/19

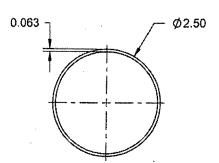
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				n:	QA: N/C	Closed: _	sed: Date:				
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		Description of NC Corrective Action Section				Ver	ification	A	Approval		
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DATE	STEP	Section A	Initial Chief Eng	Action Descriptio Chief Eng	n Sigr Dat	1& S	ection C	Approval Chief Eng	QC Inspector		
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DATE	STEP	Section A		Action Descriptio Chief Eng		1& S					
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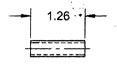
DESIGN MB	DRAWN BY MB	DART AEROSPACE HAWKESBURY, ONTARIO, C	
CHECKED	APPROVED #	DRAWING NO. D3436	REV. A SHEET 2 OF 4
DATE		TITLE	SCALE
05.0)4.28	MAINTENANCE STEP	1:2

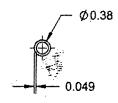




D3436-1 CLAMP

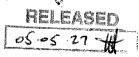
1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)





D3436-5 BUSHING

2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)



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D3436-1/ -5, GENERAL NOTES:

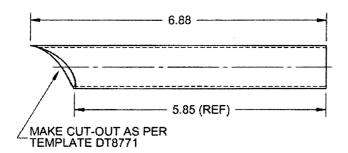
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

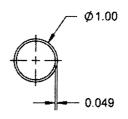
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W/O:			WO	RK ORDER CHANG	ES			,	
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		esolution:	Disposition	:	_ QA: N/C C	osed:		Date: _	
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DATE	STEP	Description of NC		Corrective Action Section		Verific		Approval	Approval
DAIL	J	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		on C	Chief Eng	QC Inspector



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECKED	APPROVED	DRAWING NO. D3436	REV. A SHEET 3 OF 4			
DATE		TITLE	SCALE			
05.04.28		MAINTENANCE STEP	1:2			

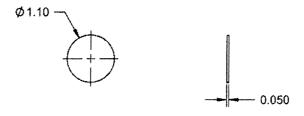




D3436-3 LEFT STEP

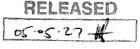
(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



D3436-7 CAP

MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)



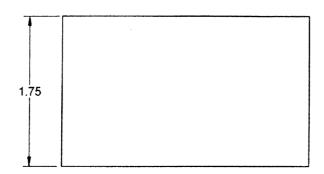
D3436-3/-7, GENERAL NOTES:

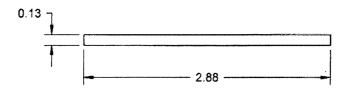
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

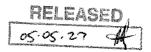
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DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE		Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da		Section C	Chief Eng	QC Inspector
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DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
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108	7四	D3430	SHEET 4 OF 4				
DATE		TITLE	SCALE				
05.04.28		MAINTENANCE STEP	1:1				







D3436-9 PAD

NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK (REF. DART SPEC. M-NEO60-S.125) 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES										
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